

Work Order ID 67658

Tuesday, March 29, 2011 9:11:46 AM



Page 1

Item ID: D4148-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Fwd

Start Date: 3/30/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

mf

Date: 11-03-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4148

D

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

ES 11/04/19 (3)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 11/04/19

(3)

120

Identify as per dwg & Stock Location: *ST 468*

0.00



Packaging

Memo

0.00

Packaging

LB 11/04/19 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

Item ID: D4148-041

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Start Date: 3/30/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/2011
ME
11-04-20

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Picklist Print

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Page 1

Work Order ID: 67658

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd



Start Date: 3/30/2011

Required Date: 4/5/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
 IPP Rev:B 10.07.22 as per revB DD verf:JLM IPP Rev:C
 10.10.29 as per revC DD verf:EC IPP REV:D 11.03.02
 AS PER DWG REV.D DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6 Lanyard Assembly		Manufactured	No			100	Each	42.0000	1	3		3/30/04/19	
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				ST020				42					
				66029				3					
				66509				19					
				66873				20					
D3910-1 Crosstube Lug		Manufactured	No			100	Each	11.0000	1	3		3/30/04/19	
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				st507				11					
				65631				11					
D4091-1 Mounting Lug		Manufactured	No			100	Each	16.0000	1	3		3/30/04/19	
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				ST460				16					
				65626				16					

B 57818 (2x)

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Tuesday, March 29, 2011 9:11:39 AM

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Work Order ID: 67658

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 3/30/2011

Required Date: 4/5/2011

Start Qty: 3.00

Required Qty: 3.00

D4148-1
Crosstube Lug Plate, Fwd

Manufactured No

100 Each

4.0000

2

Location

Loc Qty

Loc Code

ST132

4

66889

4

D4148-3
Stud Receiver, Lower

Manufactured No

100 Each

0.0000

1

D4148-5
Eyebolt Stud

Manufactured No

100 Each

4.0000

1

Location

Loc Qty

Loc Code

ST133

4

66890

4

AN3C12A
Bolts

Purchased No

100 Each

63.0000

2

Location

Loc Qty

Loc Code

ST351

63

115392

3

115594

5

116786

5

116924

50

AN4C13A
BOLT

Purchased No

100 Each

26.0000

3

Location

Loc Qty

Loc Code

ST357

26

116914

26

6
E 5/11/04/19
B67735

3
B67733 (3x) E 5/11/04/19

3
E 5/11/04/19
B67736 (3x)

6
E 5/11/04/19

1117313 (5x)

9
E 5/11/04/19
1117366 (9x)

Tuesday, March 29, 2011 9:11:39 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Tuesday, March 29, 2011 9:11:39 AM

Page 3

Work Order ID: 67658

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 3/30/2011

Required Date: 4/5/2011

Start Qty: 3.00

Required Qty: 3.00

MS17984-C413 Purchased

No

100

Each

10.0000

1

3



PIN, QUICK RELEASE

Location

Loc Qty

Loc Code

ST315

10

116823

10

3

MS20615-4M18 Purchased

No

100

Each

61.0000

8

24



Rivet

Location

Loc Qty

Loc Code

GA

61

115037

61

MS21043C3 Purchased

No

100

Each

0.0000

2

6



Nut

MS21043C4 Purchased

No

100

Each

0.0000

3

9



Nut

NAS1149C0332R Purchased

No

100

Each

285.0000

4

12



Washer

Location

Loc Qty

Loc Code

ST297

285

115832

54

116304

231

M117291 (12x)

W/O:		WORK ORDER CHANGES					
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Tuesday, March 29, 2011 9:11:40 AM

Page 4

Work Order ID: 67658

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 3/30/2011

Required Date: 4/5/2011

Start Qty: 3.00

Required Qty: 3.00

NAS1149C0432R

Purchased

No

100

Each

1,650.000

6

18



Washer



EP 4/04/11

Location

Loc Qty

Loc Code

ST297

1650

116900

1650

18

Tuesday, March 29, 2011 9:11:40 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

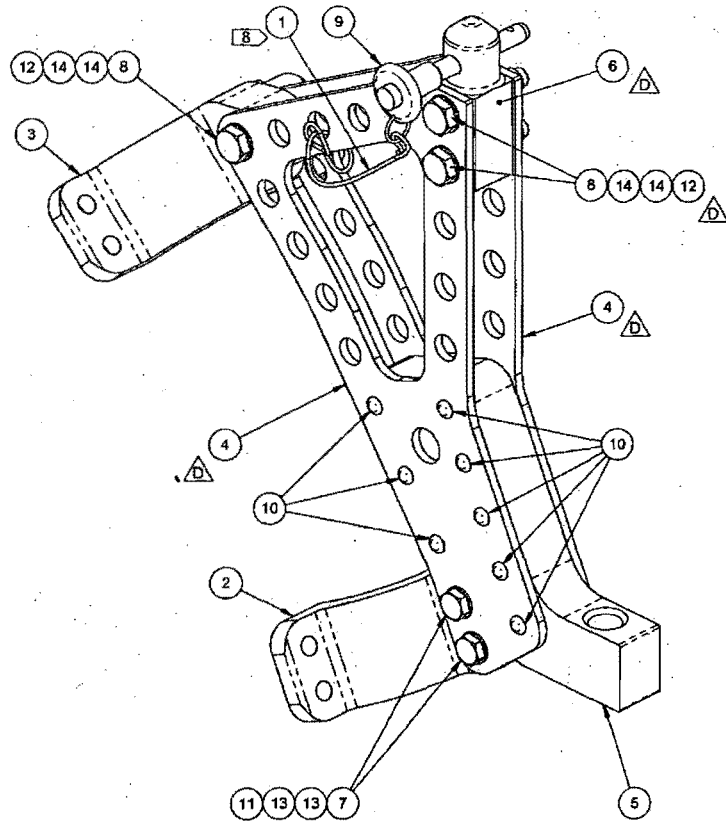
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4148-041 FWD X-TUBE LUG ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
 - 7) WEIGHT: 3.67 lbs
 - 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	2	AN3C12A	BOLT
8	3	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	8	MS20615-4M18	RIVET
11	2	MS21043C3	NUT
12	3	MS21043C4	NUT
13	4	NAS1149C0332R	WASHER
14	6	NAS1149C0432R	WASHER

67653

RELEASED
2011-02-24

D	HOLE DIA CHANGED TO 0.252" (D3-3); HOLE DIA CHANGED TO 0.250" (D3-6); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, C4-2)	SC	11.02.22
C	REDESIGNED D4148-1/3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-331 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D6-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS 0.129 (ZN C3-3); REASON: SEE TR-D350-407-2 REV. 8.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS RECOGNITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

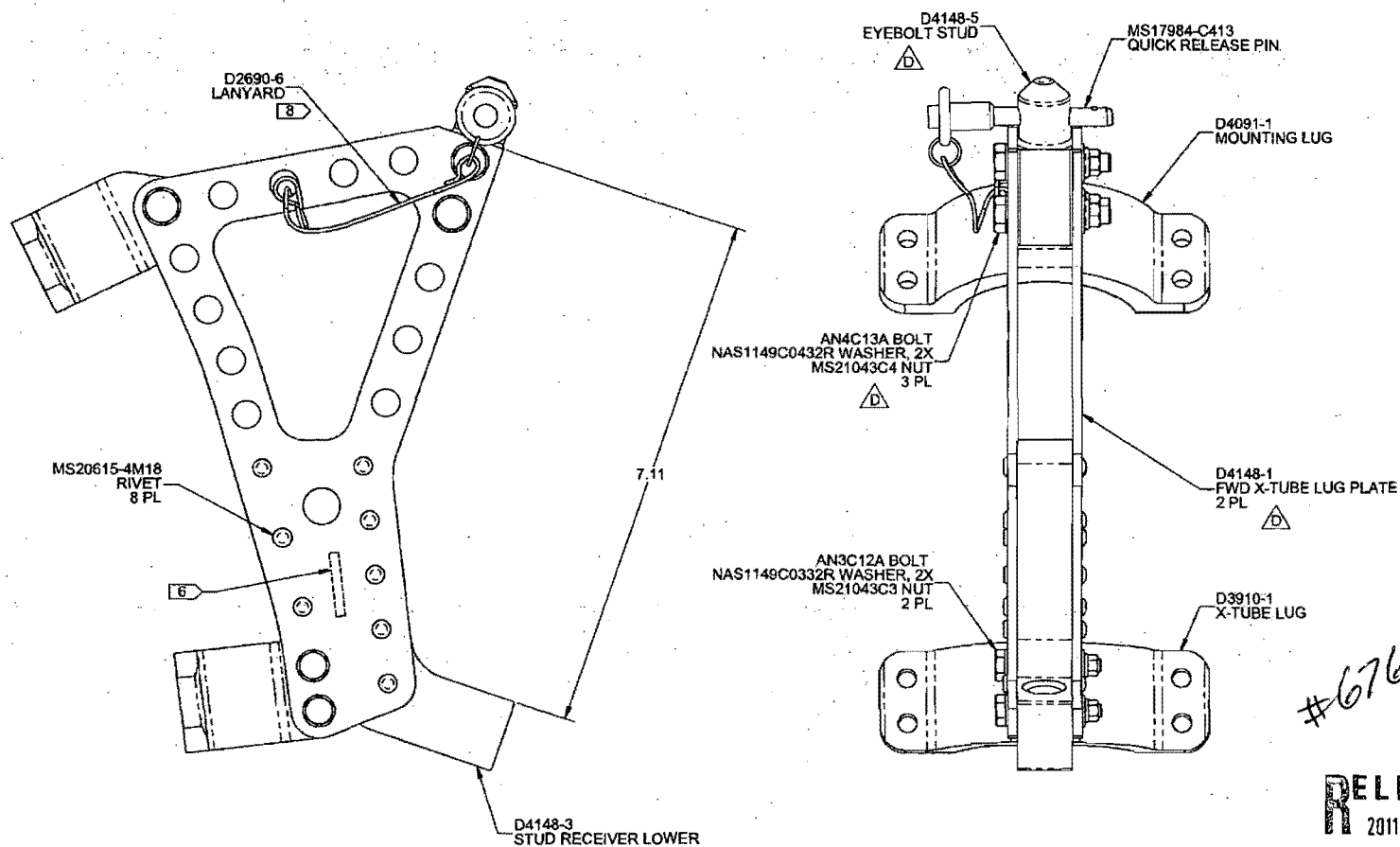
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D4148-041 FWD X-TUBE LUG ASSY

RELEASED
2011-02-24

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
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MFG. APPR.		D4148	SHEET 2 OF 5
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DE APPR.		FWD X-TUBE LUG ASSY	NTS
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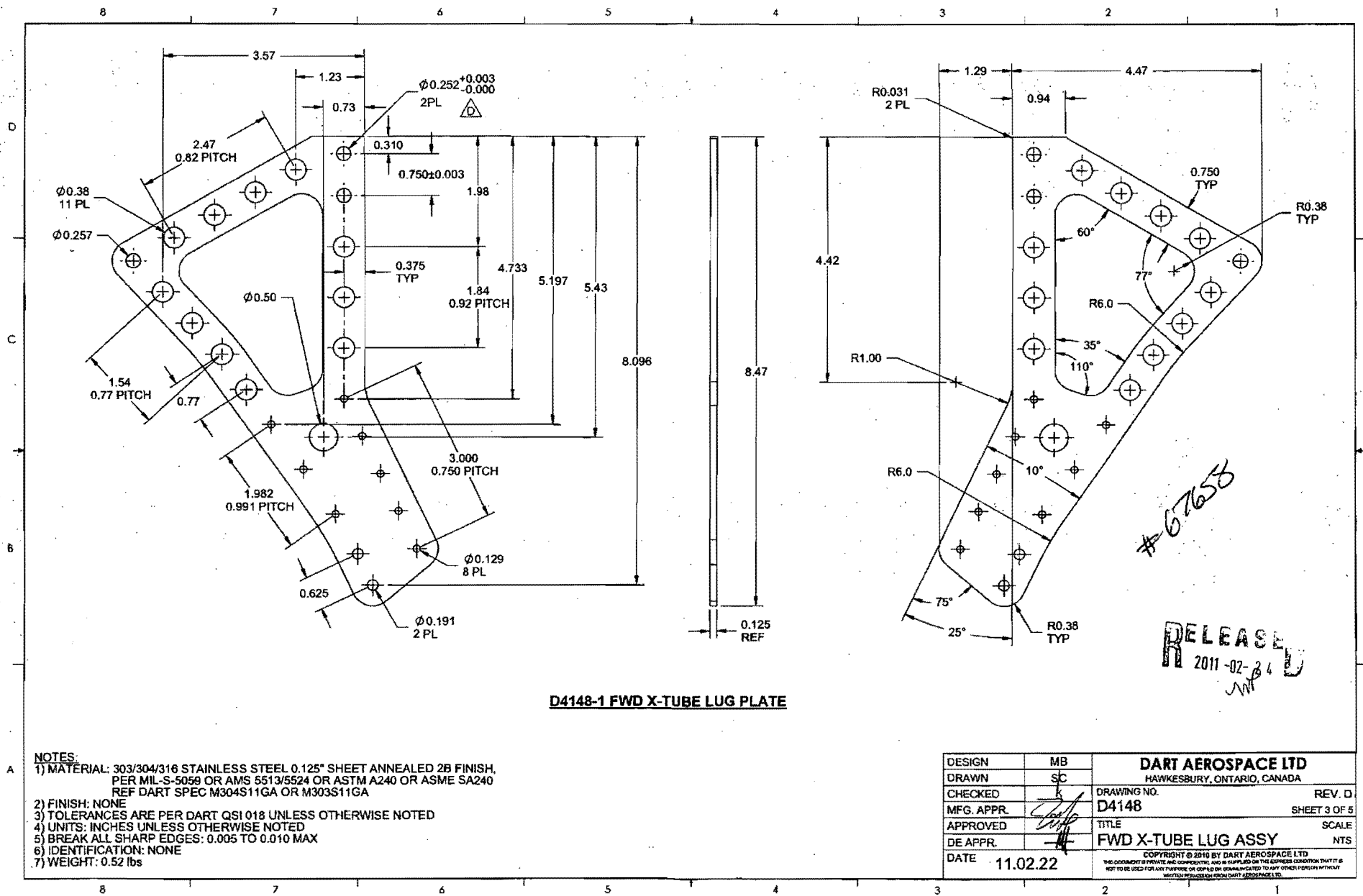
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D4148-1 FWD X-TUBE LUG PLATE

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.52 lbs

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MFG. APPR.		D4148	SHEET 3 OF 5
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#67658

RELEASE
2011-02-24

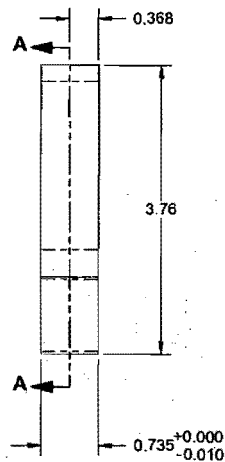
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NOTE: Date & initial all entries

[illegible]

RELEASED
2011-02-24

7) WEIGHT: 1.52 lbs

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CHECKED		DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4148	SHEET 4 OF 4
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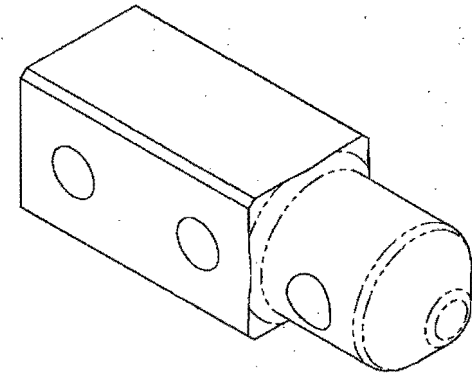
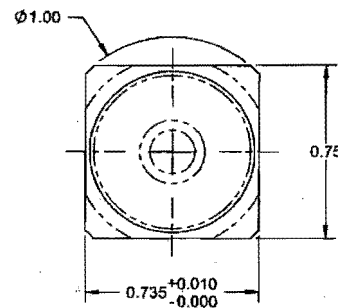
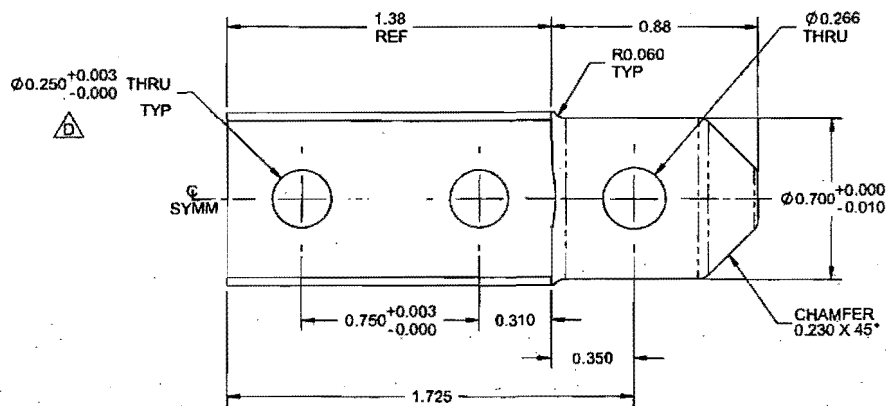
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D4148-5 EYEBOLT STUD

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4148	SHEET 5 OF 5
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